

Thursday, April 19, 2012 10:26:57 AM

Item ID: D3370-3

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

**Item Name:** Pedal Lock Cover

**Start Date:** 4/19/2012      **Start Qty:** 5.00

**\*5\***

**Cust Item ID:**

**Required Date:** 4/27/2012      **Req'd Qty:** 5.00

**\*5\***

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date: 2-04-19

### Tooling:

**Date:**

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):**

Date:

Stop **\*NR2\***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83514

**\*83514\***

Page 2

Thursday, April 19, 2012 10:26:57 AM

Item ID: D3370-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Pedal Lock Cover  
 Start Date: 4/19/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 4/27/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				5			
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				5			
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
<b>*150*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

START TIME: 3:45 OVEN TEMPERATURE: 4:15  
 FINISH TIME: 3:20 OF  
 W113645

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 83514****\*83514\***

Page 3

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Item ID: D3370-3

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Pedal Lock Cover

Start Date: 4/19/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12074

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 19, 2012 10:27:01 AM

Page 1

Work Order ID: 83514

\*83514\*

Parent Item: D3370-3

\*D3370-3\*

Parent Item Name: Pedal Lock Cover

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP B05.05.25Added Powder CoatKJ/JLM  
IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	70.9900	0.3483	1.833158			

\*M6061T6B1 500X02 500\*

\*\*

6061-T6 Bar 1.50 x 2.50

Location	Loc Qty	Loc Code
MAT004	70.99	
103069	12	
→ 107387	22.99	
16742	36	

1.84 *ml 12/06/28*

W/O:		WORK ORDER CHANGES					
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 83574
<b>Description:</b> Pedal Lock Cover		<b>Part Number:</b> D3370-3
<b>Inspection Dwg:</b> D3370	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.000	—		Vernier	
3.344	+/-0.010	3.343	—		"	
0.592	+/-0.010	.592	—		"	
0.202	+/-0.010	.202	—		"	
Ø1.000	+0.005/-0.000	Ø1.000	—		"	
0.25	+/-0.030	.241	—		"	
2.000	+/-0.010	2.000	—		"	
0.300	+/-0.010	.292	—		"	
0.550	+/-0.010	.547	—		"	
1.50	+/-0.030	1.495	—		"	
Ø1.250	+0.005/-0.000	Ø1.250	—		"	
0.635	+0.010/-0.000	.635	—		"	
Ø0.750	+0.010/-0.000	Ø.758	—		"	
1.673	+/-0.010	1.671	—		"	
0.430	+/-0.010	.428	—		"	
2.638	+/-0.010	2.636	—		"	
2.35	+/-0.030	2.350	—		"	
0.715 deep	+/-0.010	.713	—		"	
15°	+/-0.1°	15°	—		"	
0.19 x 45°	+/-0.030	.183 x 45°	—		"	
0.450	+/-0.010	.450	—		"	
1.450	+/-0.005	1.450	—		"	

<b>Measured by:</b> <i>AK</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 12/06/29	<b>Date:</b> 12/06/29	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	
D	10.04.20	Dimensions revised per Dwg Rev C	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

△C

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN526C832R6	SCREW

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83514  
RD

12-04-19

RELEASED  
08-07-16

C	SHEET 1 ADDED P/L, ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D3370	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	08.07.11	COPY RIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

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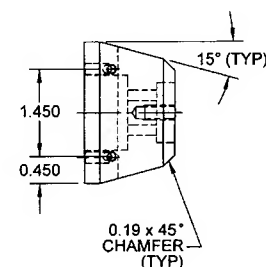
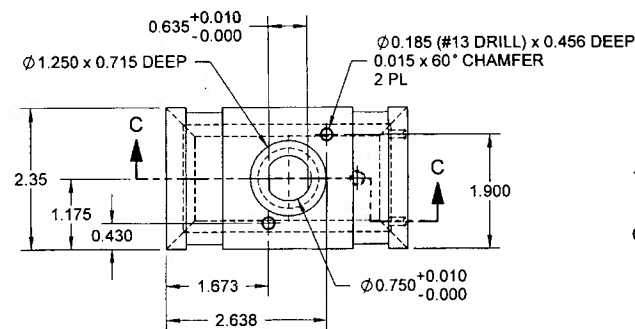
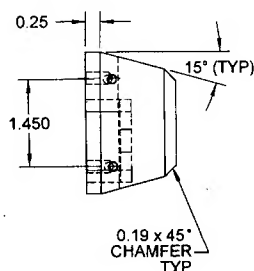
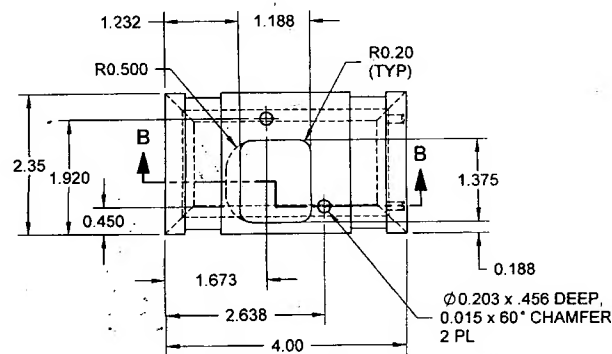
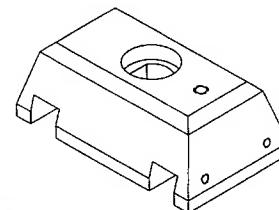
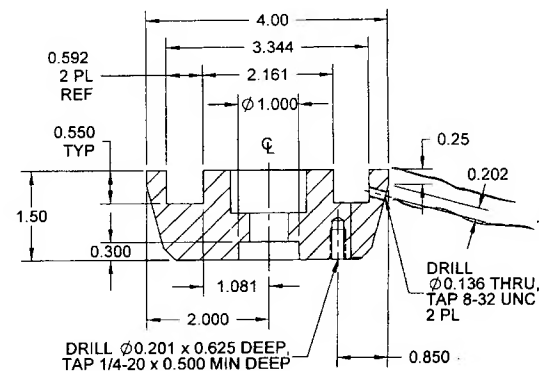
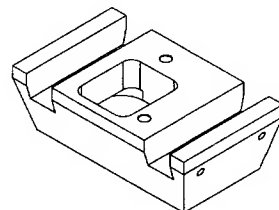
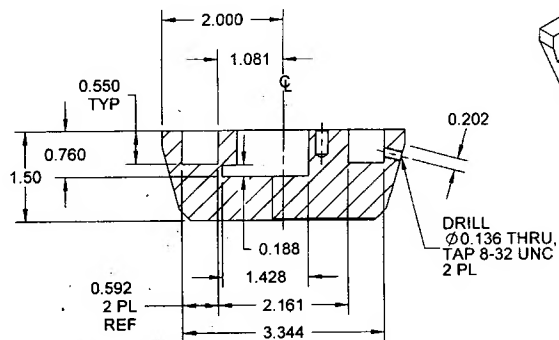
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# NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3370</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>PEDAL LOCK</b>	NTS
DATE	08.07.11	<small>           COPYRIGHT © 2004 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.         </small>	

RELEASED  
08-07-16

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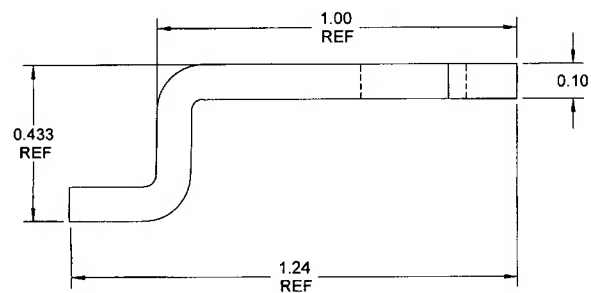
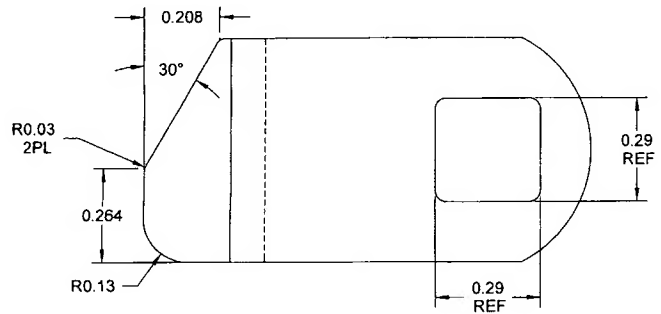
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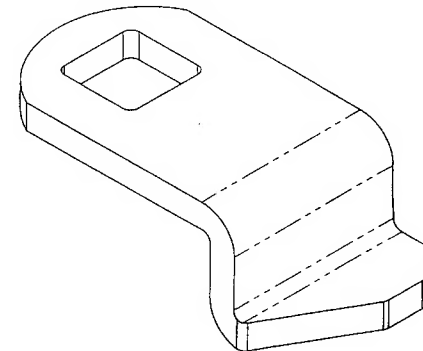
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**NOTE:** Date & initial all entries





**D3370-5 CAM**



63514

**RELEASED**  
76014

**NOTES:**

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3370</b>	SHEET 4 OF 4
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